

Work Order ID 101239

\*101239\*

Item ID: D3560-041

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Arm Weldment

Start Date: 5/07/13 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 5/21/13 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals: Process Plan: MJS Date: 13-05-07

Tooling:

Date:

Run Start \*NR1\*

QC: Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3560	Rev D
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100

0.00

\*100\*

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks 16.750" long

mk 13/05/08

5

110

0.00

\*110\*

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA693 Rev: 4A & Dwg D3560 Rev: 2-C'sink 0.196" hole on manual mill as per dwg D3560 3-Deburr per dwg D3560

mk 13/05/11

MM 13/05/12

5

120

0.00

\*120\*

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

mk 13/05/11

5

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

**FAULT CATEGORY**

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Work Order ID 101239

\*101239\*

Page 2

Item ID: D3560-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Arm Weldment

Start Date: 5/07/13 Start Qty: 6.00

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Cust Item ID:

Required Date: 5/21/13 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00

5/13-5-13

5

\*130\*

QC

Memo

0.00

Quality Control

140

Large Fab

0.00

\*140\*

Large Fab

Memo

0.00

(4)

13-09-05 PD

Large Fab

1-Weld assembly as per dwg D3560

STEP:

1- clean material (buff bracket and bottom of arm with blue pad )

2- set up bracket and arm on jig

3- preheat bracket and arm with torch

4- clean before welding with brush

5- set up machine to 135 amps

6- weld across bottom and top ends

7- reheat with torch ( 65 deg C )

8- on one side weld from bottom to top half way

9- same for other side (half way)

10- from half way point weld the rest of the first side (ease off pedal near

end) 11- same for remaining side (ease off pedal near end)

PD →

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: *[Signature]*

Date: 13/09/12

QA Closed: *[Signature]*

Date: 13/9/13

Work Order: <u>101239</u> Part No. <u>D3560-041</u> NCR No. <u>13-3020</u>				<b>DISPOSITION</b> Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b> <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input checked="" type="checkbox"/> <i>welding</i> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>	13/09/05	140	x1	Part cracked when welding D3560-1 to its plate.	DAS 16 9-89  Q52042 13/09/05	Scrap & Destroy  No Replate.  \$1167.44	DD 13-09-05	DAS 27 39  13 9 6	DAS 16 9-89  Q52042 13/09/05
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input checked="" type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

**FAULT CATEGORY**

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input checked="" type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input checked="" type="checkbox"/> Other
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*Cracked when welding*

Work Order ID 101239

10-07-13 10-01-19 AM

\*101239\*

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\*N900040100\*

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Revision ID:

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Start Date: 5/07/13 Start Qty: 6.00

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\*6\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150 QC5- Inspect part completeness to step on W/O

0.00

DAS

27

9-89

\*150\*

QC

Memo

0.00 13 9.6

Quality Control

160 QC9- Inspect visual per QSI004- Fusion Welds

0.00

\*160\*

QC

Memo

0.00

Quality Control

170 Chemical Conversion Coat per QSI005 4.1

0.00

\*170\*

HandFinish

Memo

0.00

Hand Finishing

DAS  
18  
9-89

4 8 13-09-00

4 13-99

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other
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Work Order ID 101239

Aug 07 13 10 01 19 AM

\*101239\*

Page 1

Item ID: D3560-041

Accept

\*N900040100\*

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Revision ID:

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC5- Inspect Part Finish  Memo	0.00  0.00				4x			13/09/09
190 *190* Small Fab Small Fab Small Fab	Small Fab  Memo I-Press bushing in D3560 arm per dwg D3562	0.00  0.00				4x			13/09/09
200 *200* QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				4			13/09/09

NCR: Yes / No

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location	0.00							
<b>*210*</b>						4	0		
Packaging	Memo	0.00							
Packaging	*** STOCK IN STEP CELL***								13-09-10
220	QC21- Final Inspection - Work Order Release	0.00							
<b>*220*</b>									13/9/11
QC	Memo	0.00							
Quality Control									

13-09-10

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  <div style="display: flex; justify-content: space-around;"> <div> <input type="checkbox"/> Rework  <input type="checkbox"/> Scrap  <input type="checkbox"/> Use-as-is  <input type="checkbox"/> Work Order Update         </div> <div> <input type="checkbox"/> Skid-tube  <input type="checkbox"/> Machining  <input type="checkbox"/> Thermoforming  <input type="checkbox"/> Large Fab         </div> <div> <input type="checkbox"/> Crosstube  <input type="checkbox"/> Small Fab  <input type="checkbox"/> Finishing  <input type="checkbox"/> Composite         </div> <div> <input type="checkbox"/> Water Jet  <input type="checkbox"/> Prod. Eng. Coord.  <input type="checkbox"/> Rec/Store/Packaging  <input type="checkbox"/> Supplier         </div> <div> <input type="checkbox"/> Engineering  <input type="checkbox"/> Quality  <input type="checkbox"/> Other         </div> </div>	
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# Picklist Print

Work Order ID: 101239

Parent Item: D3560-041

Parent Item Name: Arm Weldment

\*101239\*

\*D3560-041\*

Start Date: 5/07/13

Required Date: 5/21/13

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07.05.24 EC  
IPP rev B ECN 987 07.10.09 EC verified by: DD  
IPP Rev:C ECN1048 07-12-18 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2808		Manufactured	No			100	Each	55.0000	1	6			
*D2808*									**				
Bushing													

Location	Loc Qty	Loc Code
GA	55	
85479	15	
97988	40	

M6061T6B0.500X05.00		Purchased	No			140	f	28.7900	1.395	8.810526			
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\*M6061T6B0 500X05 000\*

6061-T6 Bar .500 x 5.00

Location	Loc Qty	Loc Code
MAT002	28.79	
125257	28.79	

D3592-1		Manufactured	No			190	Each	46.0000	1	6			
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\*D3592-1\*

Plate

Location	Loc Qty	Loc Code
WA002	2	
47015	2	
WA003	44	
80379	3	
82022	8	
<del>97778</del>	33	

B103585 - (S)

13-09-05 PD

13/09/09

7.33 on 13/05/08

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
<b>Root Cause</b>	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											

FAULT CATEGORY											
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other

DART AEROSPACE LTD		Work Order:	101239
Description: Arm		Part Number:	D3560-1
Inspection Dwg: D3560 Rev: D		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

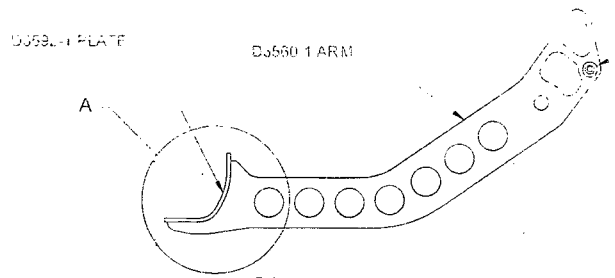
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.507	+0.000/-0.001	Ø.5069	—		Micr	M-L-D7
Ø0.196	+0.005/-0.001	Ø.197	—		Vern	M-L-D8
Ø1.000	+0.010/-0.001	Ø1.005	—		"	"
0.500	+/-0.010	.500	—		"	
0.250	+/-0.010	.250	—		"	
0.275	+/-0.010	.275	—		"	
0.188	+/-0.010	.191	—		"	
2.000	+/-0.010	2.003	—		"	
1.700	+/-0.010	1.703	—		"	
Ø0.385 x 100°	+/-0.010 x 0.5°	.385x.100°	—			
0.250 Deep	+/-0.010	.249	—		"	

Measured by:	<i>Amf</i>
Date:	13/05/11

Audited by:	<i>SA</i>
Date:	13-5-13

Prototype Approval:	N/A
Date:	N/A

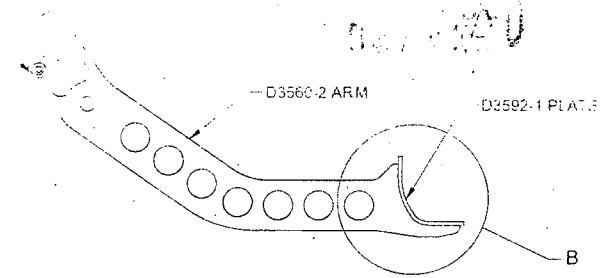
Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue P/O D3560-041	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM	
C	08.07.24	Dwg Rev updated	KJ/DD	<i>DD</i>



**D3560-041 ARM WELDMENT**

D2808 SPACER  
PRESS FIT AFTER  
ALODINE

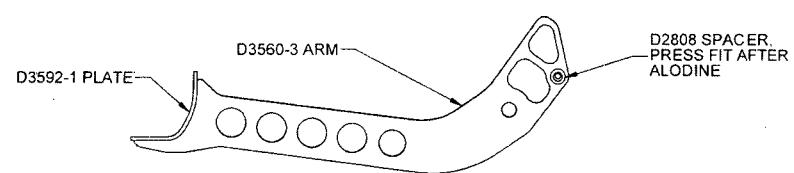
D2808 SPACER  
PRESS FIT AFTER  
ALODINE



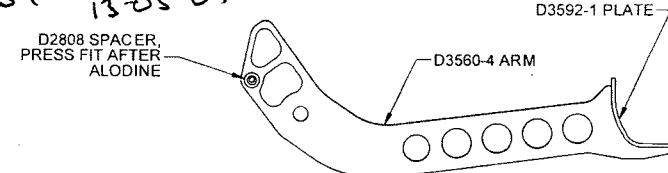
**D3560-042 ARM WELDMENT**

UNCO  
SUB

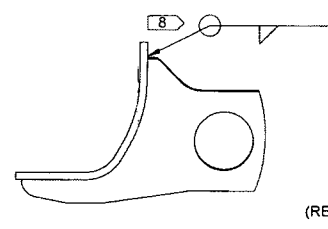
NO 101239 MLC  
1305-07



**D3560-043 ARM WELDMENT**



**D3560-044 ARM WELDMENT**



**DETAIL A  
SCALE 1:2**

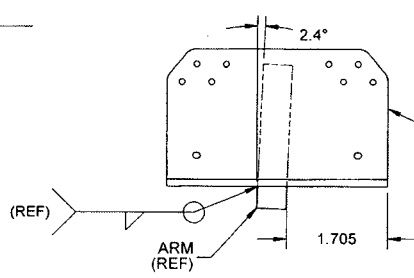
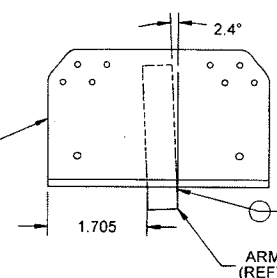
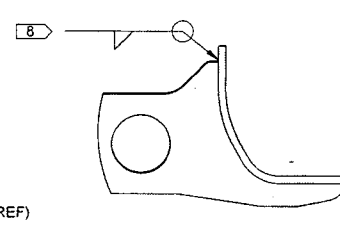


PLATE  
(REF)



ARM  
(REF)



**DETAIL B  
SCALE 1:2**

**PARTS LIST**

QTY -041	QTY -042	QTY -043	QTY -044	P/N	DESCRIPTION
X				D3560-041	ARM WELDMENT
	X			D3560-042	ARM WELDMENT
		X		D3560-043	ARM WELDMENT
			X	D3560-044	ARM WELDMENT
1	1	1	1	D2808	SPACER
1				D3560-1	ARM
	1			D3560-2	ARM
		1		D3560-3	ARM
			1	D3560-4	ARM
1	1	1	1	D3592-1	PLATE

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.23 lbs (TYP)
- 8) WELDING: PER DART QSI 004

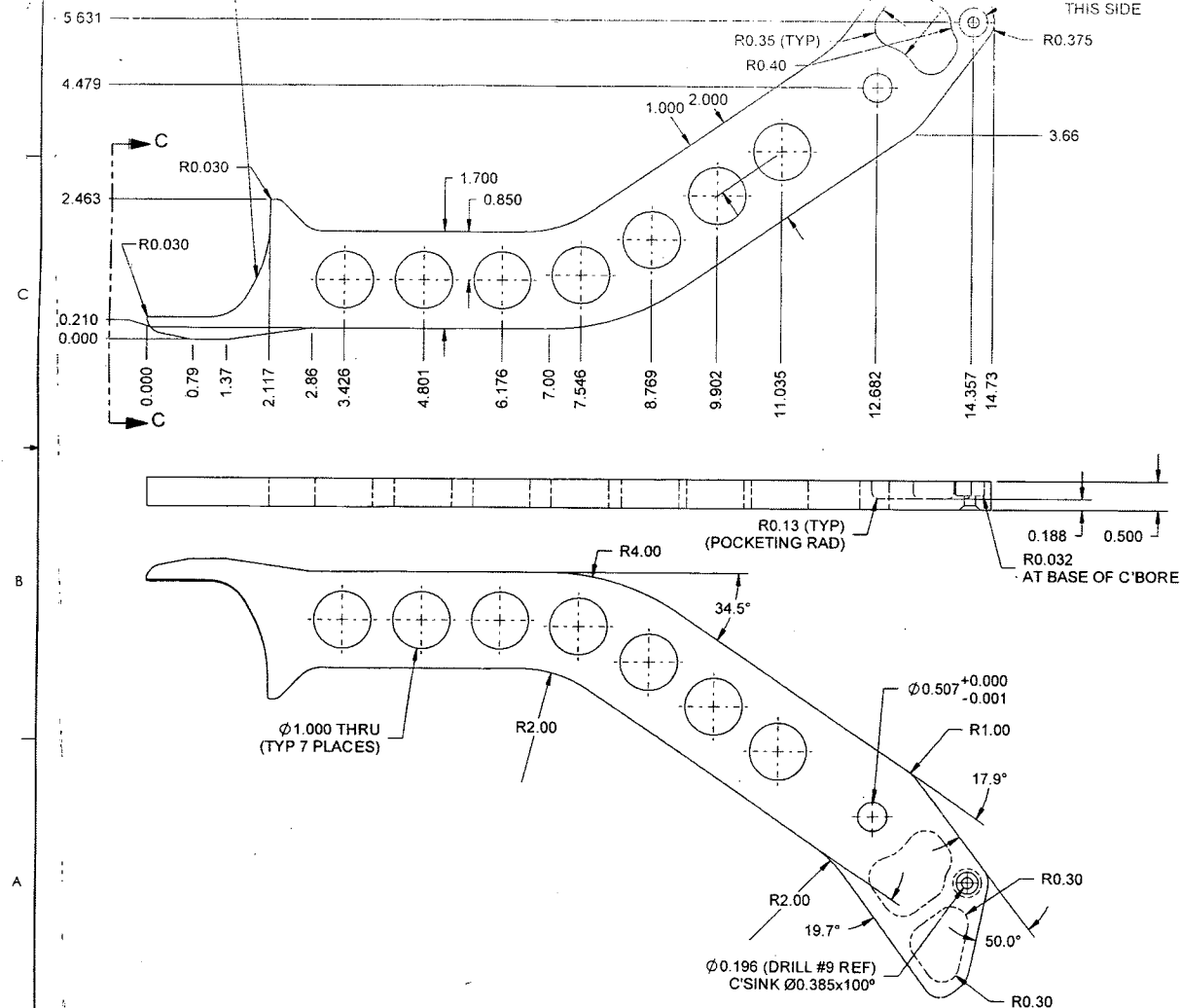
D	ADD D2808 PRESS FIT NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
C	REMOVE POWDER COAT	CP	07.06.19
B	REDESIGN AS WELDMENT, ADD POCKETS	CP	07.01.15
A	NEW ISSUE	CP	06.09.25
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	JP		
CHECKED	JP		
MFG. APPR.	JP		
APPROVED	JP		
DE APPR.	JP		
DATE	07.11.16		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3560** REV. D  
SHEET 1 OF 5  
TITLE **ARM WELDMENT** SCALE 1:4

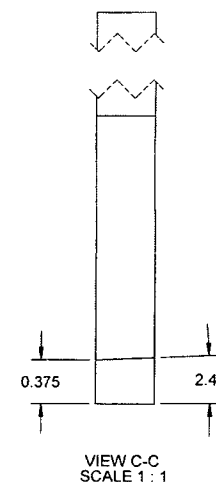
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WRITTEN PERMISSION FROM DART AEROSPACE LTD

REF. TO V-107  
D3592-1 PLATE.  
MACHINE AT 24°  
SEE VIEW C-C



NOTES:

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T5510/T6511/T62) BAR, 0.500 THICK  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B0.500)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 1.05 lbs



11-12-88

DESIGN	<i>g</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <b>D3560</b>  TITLE <b>ARM WELDMENT</b>  COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMERCIALIZED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	REV. D
DRAWN	<i>dc</i>		SHEET 2 OF 5
CHECKED	<i>g</i>		SCALE
MFG APPR.	<i>g</i>		1:2
APPROVED	<i>g</i>		
DE APPR.	<i>g</i>		
DATE	07.11.16		

Technical drawing of a ship's hull cross-section. The drawing includes the following dimensions and features:

- Top Dimensions:**
  - 0.250 (DEEP FROM THIS SIDE)
  - 0.001
  - 0.000
  - 0.507
  - 0.275
  - 0.375
  - 0.40
  - 0.35 (TYP)
- Vertical Dimensions (Left Side):**
  - 14.73
  - 14.357
  - 12.682
  - 11.035
  - 9.902
  - 8.769
  - 7.546
  - 7.00
  - 6.176
  - 4.801
  - 3.426
  - 2.86
  - 2.117
  - 1.37
  - 0.79
  - 0.000
- Vertical Dimensions (Right Side):**
  - 5.631
  - 4.479
  - 2.463
  - 0.210
  - 0.000
- Horizontal Dimensions:**
  - 2.000
  - 1.000
  - 1.700
  - 0.850
- Curvature and Radii:**
  - R0.75
  - R0.40
  - R0.35 (TYP)
  - R0.030
  - R0.030
- Other Labels:**
  - C/BORE
  - THIS SIDE

D3560-2 ARM

## NOTES

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs

R0.032  
AT BASE OF C'BORE

R0.13 (TYP)  
(POCKETING RAD)

R2.00

Ø1.000 THRU  
(TYP 7 PLACES)

$\phi 0.507^{+0.000}_{-0.001}$

R1.00

17.9°

Ø0.196 (DRILL #9 REF)  
C'SINK Ø0.385x100°

R0.30

50.0°

R0.30

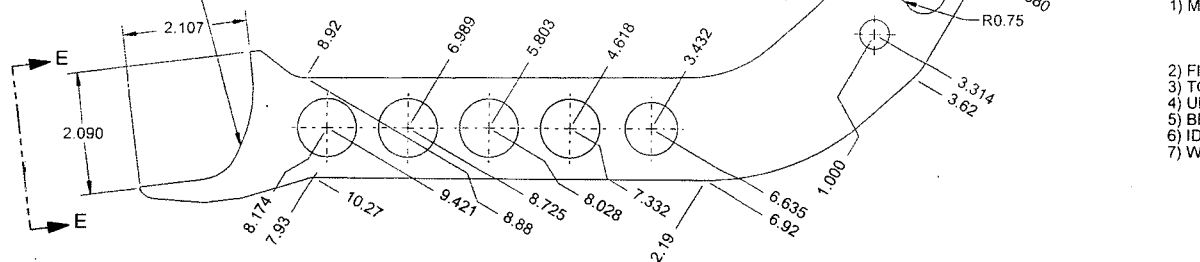
VIEW D-D  
SCALE 1 : 1

DESIGN	02	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <b>D3560</b>  TITLE <b>ARM WELDMENT</b>  COPYRIGHT © 2006 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE COPIED OR FOR ANY PURPOSE OR COMMERCIAL USE WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	REV. D
DRAWN	JC		SHEET 3 OF 5
CHECKED	MB		SCALE
MFG. APPR.	MB		1:2
APPROVED	MB		
DE APPR.	MB		
DATE	07.11.16		

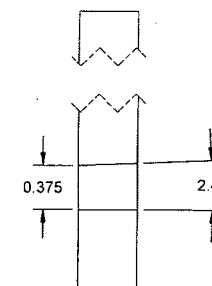
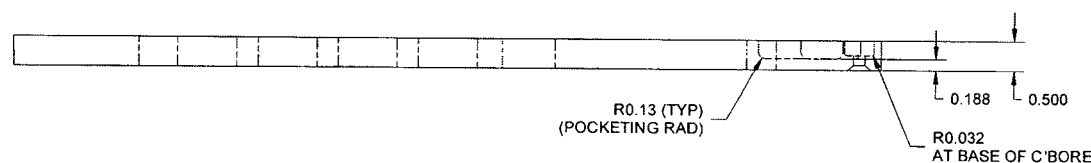
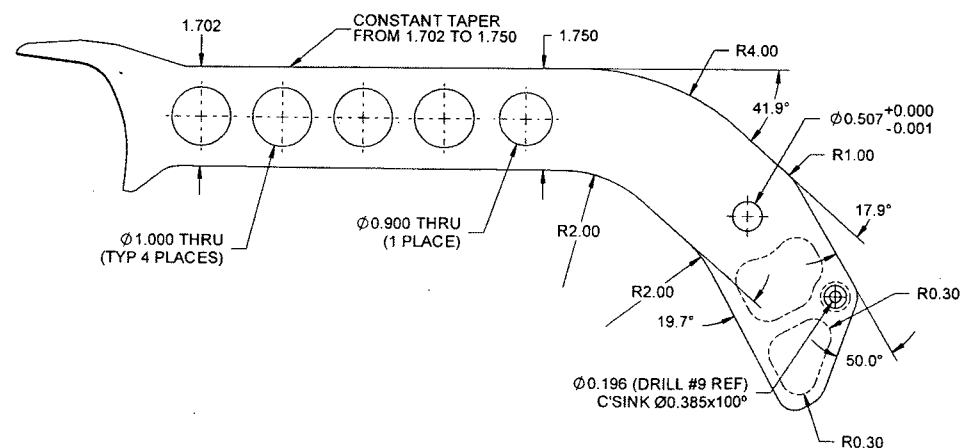


101239

PROFILE TO MATCH  
D3592-1 PLATE  
MACHINE AT 2.4°  
SEE VIEW E-E

**D3560-3 ARM****NOTES:**

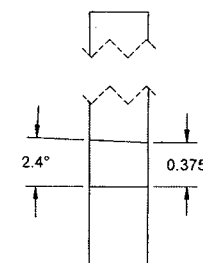
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs

VIEW E-E  
SCALE 1:1


DESIGN	q	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	4C			
CHECKED	4		DRAWING NO.	REV. D
MFG. APPR.	4		D3560	SHEET 4 OF 5
APPROVED	MD		TITLE	SCALE
DE APPR.	4		ARM WELDMENT	1:
DATE	07.11.16		COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

PROFILE TO MATCH  
D3592-1 PLATE,  
MACHINE AT 2.4°,  
SEE VIEW F-F

**NOTES:**  
1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B0.500)  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 1.05 lbs



VIEW F-F  
SCALE 1 : 1

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3560	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		ARM WELDMENT	1:2
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